

### Abstract of the Disclosure

A method and apparatus of turning a board while the board is being transferred in a conveyance system includes a conveyance system for transporting a board, a rotary  
5 turning device for rotating the board, a bumper stop for restraining the board and a speed-up belt for increasing or decreasing delivery of the board. The rotary turning device rotates at a constant rate relative to the conveyance system speed; the bumper stop stops the flow of the lumber allowing the rotary turning device to pick up the board; the speed-up belt accelerates the board to the front of the lug space and the conveyance system transports the board while it  
10 is turned within the lug space.